

# Work Order ID 62517

October 1, 2010 2:13:50 PM

BLUE Ship Oct-13



Page 1

Item ID: D2724-042

Accept



Setup Start



Revision ID:

Stop



Item Name: 206L Step Assembly

Start Date: 10/01/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/13/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

*[Signature]*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2724

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Cut D2724-2 using D2622 extrusion as per Dwg D2724  
Deburr and bevel ends for welding

*10.10.04*

*1 of*

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld end cap (One End Only) and lugs as per Dwg D2724 using Jig DT8898  
followed by Jig  
A/R AL ROD Batch: *M112860*  
*M114877*  
Grind end cap welds flush

*10.10.04*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Required Date: 10/13/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

① PD 10.10.04

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 10/10/04



140

Chemical Conversion Coat per QSI005 4.1

0.00



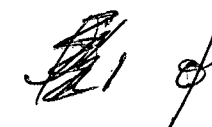
HandFinish

Memo

0.00

Hand Finishing

10.10.04



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 62517

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Item ID: D2724-042

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Setup Start

Revision ID:

Stop

Item Name: 206L Step Assembly

Start Date: 10/01/10 Start Qty: 1.00

Cust Item ID:

Required Date: 10/13/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

160

Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

Inspect for foreign object per QSI 024

Weld Remaining end cap as per Dwg D2724

A/R AL ROD Batch: M112860

Grind end plate flush.

170

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

# Work Order ID 62517

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Item ID: D2724-042

Accept

Revision ID:

Item Name: 206L Step Assembly

Setup Start

Stop

Start Date: 10/01/10 Start Qty: 1.00

Required Date: 10/13/10 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

190

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

200 201

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

-prime B114424

-delflet blue B115509

-clear B113314

BT 10-10-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Item ID: D2724-042

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Revision ID:

Item Name: 206L Step Assembly

Setup Start

Stop

Start Date: 10/01/10 Start Qty: 1.00

Required Date: 10/13/10 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

210

~~QC~~ Inspect Part Finish

0.00



QC

Quality Control

QC14

Memo

0.00

1 10-10-15

220

Wing Walk as per dwg QSI005 4.4 Batch M115028

0.00



HandFinish

Hand Finishing

Memo

0.00

10/10/15

X1 Ø

230

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

10-10-15

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

Required Date: 10/13/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

240

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

PP 62516

10/10/15



Packaging

Memo

0.00

Packaging

250

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/15  
10-10-15

# Picklist Print

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Page 1

Work Order ID: 62517

Parent Item: D2724-042

Parent Item Name: 206L Step Assembly



Start Date: 10/01/10

Required Date: 10/13/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2734

Manufactured

No

110

Each

67.0000

1

1



Step End Plate

Location

Loc Qty

Loc Code

WA

67

60216

7

61209

60

1

D2734

Manufactured

No

160

Each

67.0000

1

1



Step End Plate

Location

Loc Qty

Loc Code

WA

67

60216

7

61209

60

1

D3458-1

Manufactured

No

110

Each

25.0000

2

2



Step Mounting Plate

Location

Loc Qty

Loc Code

WA

25

51239

3

53408

22

2

D3458-3

Manufactured

No

110

Each

8.0000

2

2



Step Mounting Plate

Location

Loc Qty

Loc Code

WA

8

53409

8

2

10/10/04

10/10/04

10/10/04

10/10/04

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Page 2

Work Order ID: 62517

Parent Item: D2724-042

Parent Item Name: 206L Step Assembly



Start Date: 10/01/10

Required Date: 10/13/10

Start Qty: 1.00

Required Qty: 1.00

D2622-120C

Manufactured No

100

Each

157.4200

1

1



Step Extrusion

*10.10.04*

Location

Loc Qty

Loc Code

WA

157.42

55214

3.42

58544

26

61208

128

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

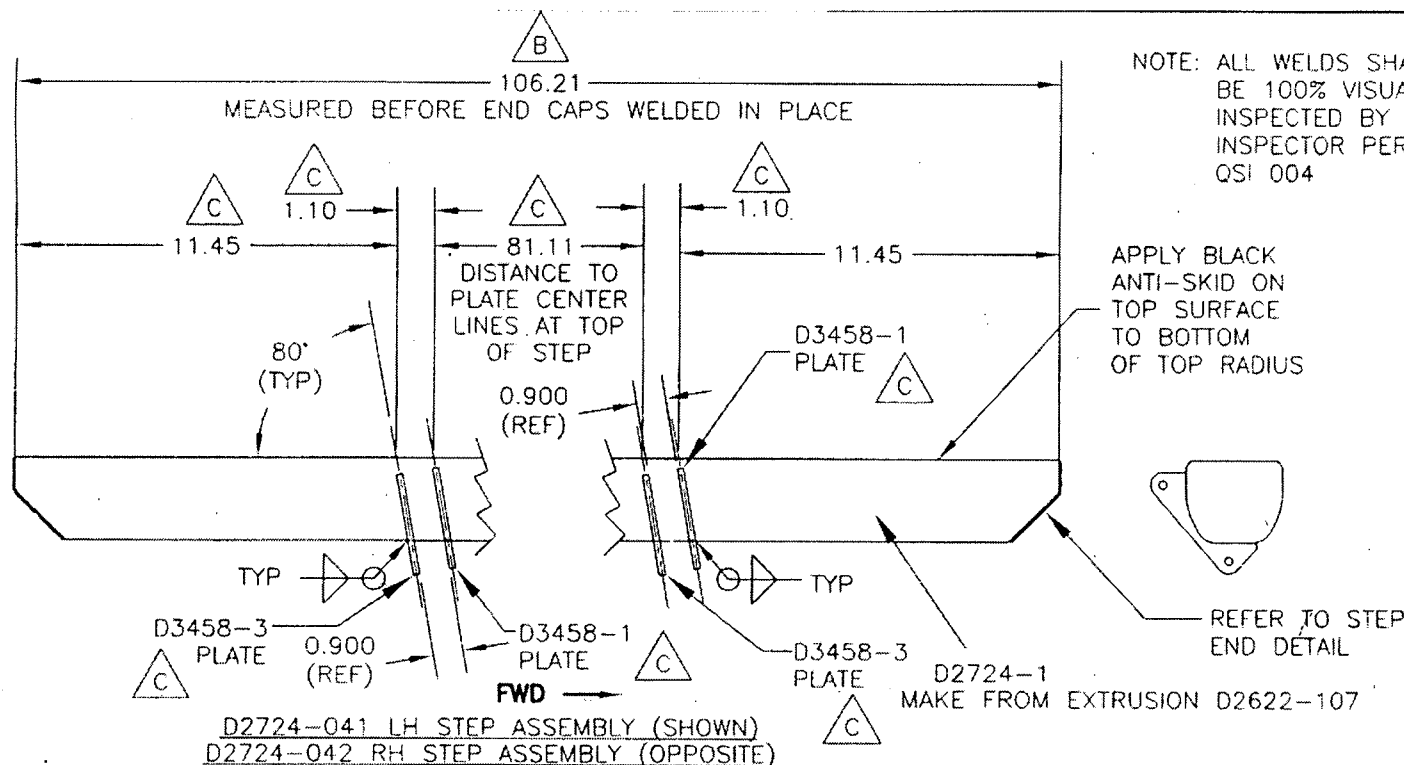
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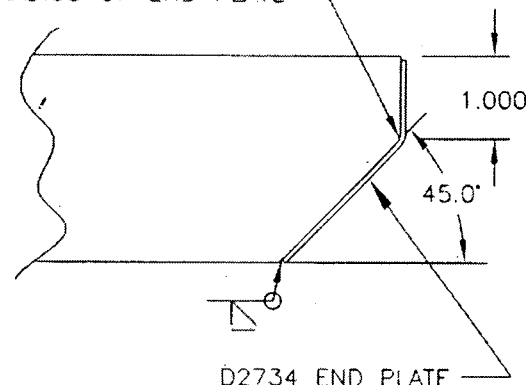
**DART**

RELEASED  
OS 0114

NOTE: ALL WELDS SHALL  
BE 100% VISUALLY  
INSPECTED BY A QUALIFIED  
INSPECTOR PER DART  
QSI 004



ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL  
NOT TO SCALE

**D2721-041/-042 STEP ASSEMBLY PARTS LIST**

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

**D2724-041/-042 STEP ASSEMBLY**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.19			
A		97.12.04		NEW ISSUE
B		98.10.19		UPDATED WELD DETAIL REVISED TOLERANCES
C		05.09.19		RE-DESIGN, ADD D3458-1/-3
TITLE				206L/407 STEP ASSEMBLY
SCALE				NTS
DRAWING NO.				D2724
SHEET 1 OF 1				
REV. C				